DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-019411
Date Inspected: 11-Jan-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Qiu Wen.

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG components.

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13BW:

Repair welding of weld joint no: SEG3014J-141 [Floor Beam (FB) to I-rib stiffener on Side Panel (SP), complete joint penetration (CJP) weld, at PP120.5]. The welder is identified as 068917 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Wang Xiang Ping. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 18318 Rev-0.

OBG Seg 14W:

Repair welding of weld joint no: SEG3020X-014 [Longitudinal Diaphragm (LD) to Bottom Panel (BP), CJP weld,

at PP127]. The welder is identified as 067520 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Wang Zhu. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): 2662 Rev-0.

Repair welding of weld joint no: SEG3020Y-030 (LD to BP, CJP weld, at PP127.3). The welder is identified as 066398 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Wang Zhu. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per CWR: 2662 Rev-0.

Repair welding of weld joint no: SEG3020Q-058 (LD3049 to FB3320, CJP weld, at PP126). The welder is identified as 047864 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Wang Zhu. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per CWR: 2620 Rev-0.

Repair welding of weld joint no: SEG3020X-012 (LD to BP, CJP weld, at PP125.5 to PP126). The welder is identified as 066734 and was observed welding in the 2G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Wang Zhu. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-2G(2F)-FCM-Repair-ESAB. Repair welding was done as per CWR: 2659 Rev-0.

OBG Seg 13AW:

ZPMC personnel performing heat straightening on weld joint no: SA3231-026 [Deck Panel (DP) 3127A to DP3126A]. Heat straightening was done as per Heat Straightening Report (HSR): 10049 Dt: 01/10/11. ZPMC QC was identified as Li Ping. Heat straightening was needed to be done to rectify the distortion after completion of welding.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on Floor beam and Longitudinal Diaphragm Stiffeners of the OBG Segment 13BW at panel point 121.5 and 122 north side.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer